

URGENT

# Work Order ID 72676

Friday, August 05, 2011 9:17:28 AM



Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference: repaint- blue-Air Evac

Run Start



Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2650	F 1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-642-341

CHG003

*see page 4*

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK:

1 X D206-642-341 B44043

REMOVE ALL HARDWARE AND WEARPLATES- DISCARD HARDWARE,

RETURN STEEL WEARPLATES TO STOCK:

6 X D2648-3 B44294

1 X D2656-11 B35897

1 X D2656-23 B43407

1 X D2656-35 B35494

1 X D3429-1 B43706

- REMOVE ALL POWDER COAT FROM TUBE

*SAUF*

-REALODINE IF NECESSARY

*FI 11-08-65*

<b>DART</b>				TEL: 1-613-632-3336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL # 09-89					
P/N	D206-642-341	CHG	CHG002		
DESC	Replacement Skidtube	STC	SH98-4		
LOT	B44043	STC	SA00475SE		
MODEL	Bell 206L/L1/L3/L4/407	STC			
US PATENT # 5,735,484 CANADA FOREIGN PATENTS PENDING				MADE IN CANADA	

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Cust Item ID:



Customer:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
205		0.00							
	SprayPaint								
Spray Painting	Memo -PRIME B 11739 -DELFLEET BLUE B 118395 -CLEAR DELFLEET B 118053	0.00							25 11-08-05
210	QC3- Inspect Part Finish	0.00							
	QC								
Quality Control	Memo	0.00							

0 B 11-08-08

**Work Order ID 72676**

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R ☐ Sikaflex-291 ☐ ☐ ☐Sikaflex expiry date: ☐M 116040  
11/08

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive

A/R ☐ Sikaflex-291 ☐ ☐ ☐Sikaflex expiry date: ☐M 116040  
11/08

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4.1

Batch:

M 118313

IX ~~Ø~~ M 11/08/08

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Customer:

Reference: repaint- blue-Air Evac

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

240 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

250 Packaging 0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341 CHG003

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

RP 70934

al819

IX Ø M-L 1/4 8/08

FC

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Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference: repaint- blue-Air Evac

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/09

mf

11-08-09

# Picklist Print

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Page 1

Work Order ID: 72676

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube




Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-130  Insert		Purchased	No				Each	2,486.000		54			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST281		432							
					117331	8							
					118386	424							
				ST282		2054							
					117717	54							
					118237	1744							
					118312	256							
AN960C10L  washer	NAS1149C0332 R	Purchased	No				Each	0.0000		54			
AN960C10L  washer	NAS1149C0332 R	Purchased	No				Each	0.0000		54			

AN960JD10L

NAS1149D0332J

M 117087 2X m.t 11/08/08

AN960JD416

NAS1149D0463J

M 118179 1X m.t 11/08/08

M 52703A-4-06

M 115460 1X m.t 11/08/08

# Picklist Print

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Page 2

Work Order ID: 72676

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D206-642-341 Manufactured No

Each 2.0000 1



Replacement Skidtube

44043



85 11-08-05

Location Loc Qty Loc Code

FG081 1  
57156 0  
57160 0  
57161 0  
69950 1

FG082 1  
36550 1

D2651-1 Manufactured No

Each 303.0000 14



Plug



m-k 11/08/08

Location Loc Qty Loc Code

fpa 109  
69018 109  
FP-A 194  
57869 1  
66445 10  
67760 36  
70691 100  
70839 2  
71037 45

D2651-3 Manufactured No

Each 308.0000 14



O-Ring



As per w/o # 44043 14x

m-k 11/08/08 \*

Location Loc Qty Loc Code

FP-A 308  
61962 12  
66956 296

B 41972 14x As per w/o # 44043 \*

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Shop Packet Print

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# Picklist Print

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Work Order ID: 72676

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Parent Item Name: Replacement Skidtube

Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3535-11

Manufactured No

Each 20.0000



Wearshoe

Location

Loc Qty

Loc Code

FP019

20

70879 ✓

7

71284

13

1  
m-l 11/08/08

IX

D3535-23

Manufactured No

Each 30.0000



Wearshoe

Location

Loc Qty

Loc Code

FP021

30

68342

2

70818 ✓

16

71581

12

1  
m-l 11/08/08

IX

D3535-35

Manufactured No

Each 27.0000



Wearshoe

Location

Loc Qty

Loc Code

FP018

14

65926

1

67598

1

70815

12

ST

13

69756 ✓

13

1  
m-l 11/08/08

IX

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# Picklist Print

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Work Order ID: 72676

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-11

Manufactured No

Each

16.0000

1



Gasket



m-p 11/08/08

Location

Loc Qty

Loc Code

FP011

16

46649

1

46715

4

65574

1

71283

10

D3536-23

Manufactured No

Each

30.0000

1



Gasket



m-p 11/08/08

Location

Loc Qty

Loc Code

FP011

30

43406

1

69902

17

71579

12

D3536-35

Manufactured No

Each

26.0000

1



Gasket



m-p 11/08/08

Location

Loc Qty

Loc Code

FP012

26

69755

12

71587

14

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# Picklist Print

Friday, August 05, 2011 9:17:25 AM

Page 5

Work Order ID: 72676

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 8/5/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No

Each 69.0000

6



Wearpad



*m-k 11/08/08*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	59	
71574 ✓	59	
FP017	10	
69817	5	
70686	2	
70972	3	

*6x*

D3537-3 Manufactured No

Each 22.0000

1



Wearpad



*m-k 11/08/08*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	21	
70481 ✓	21	
FP017	1	
35697	1	

*1x*

MS27039C1-08 Purchased No

Each 884.0000

54



SCREW



*m-k 11/08/08*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	1	
116022	1	
ST293	883	
116373 ✓	3	
118077 ✓	380	
118159	500	

*54x*

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Shop Packet Print

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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

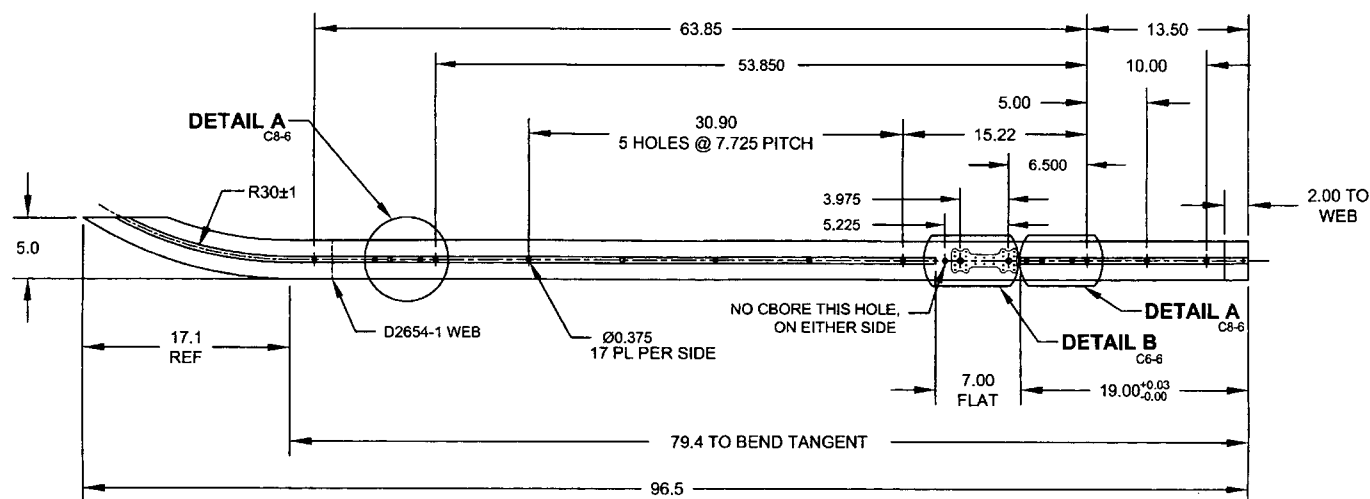
# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

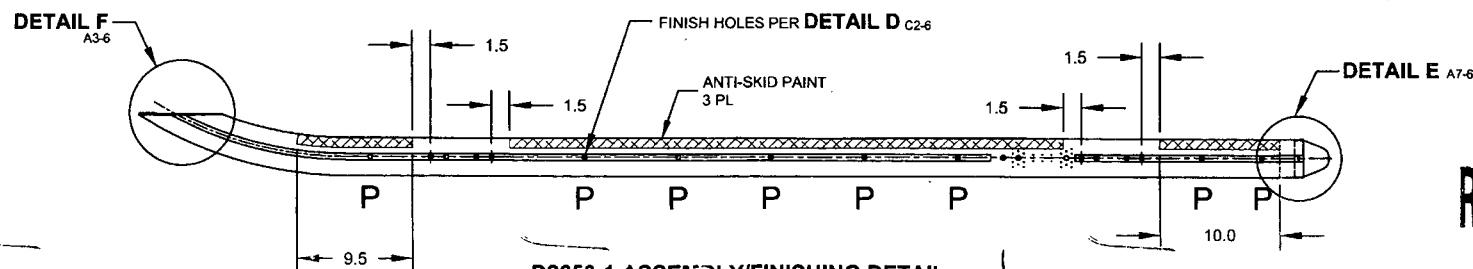
RELEASED  
08-07-23/17

72676

REV.	DESCRIPTION	BY	DATE
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DEO9136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	







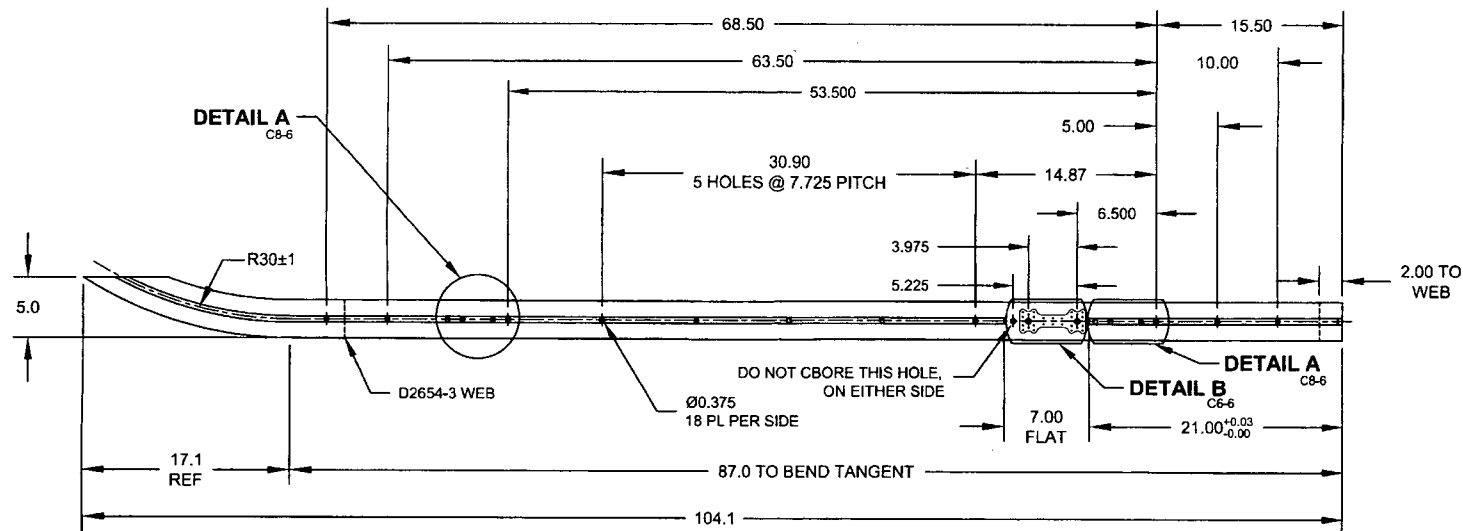
**D2650-1 BENDING/DRILLING DETAIL**



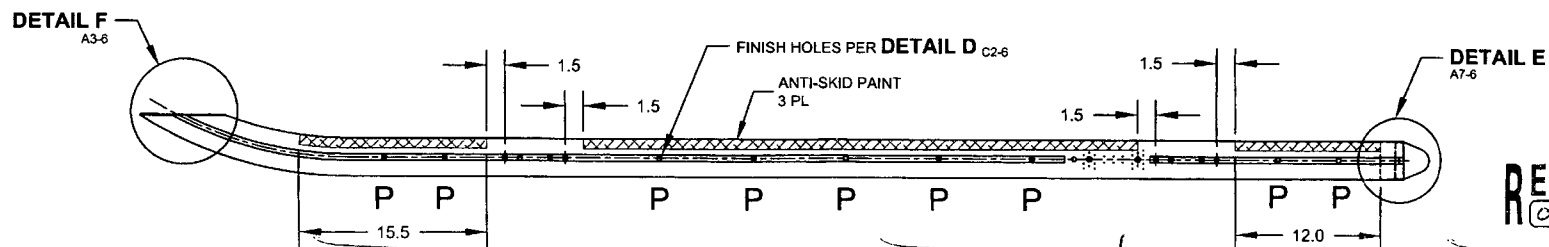
**D2650-1 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
68 09 22 11/15

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
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**D2650-3 BENDING/DRILLING DETAIL**

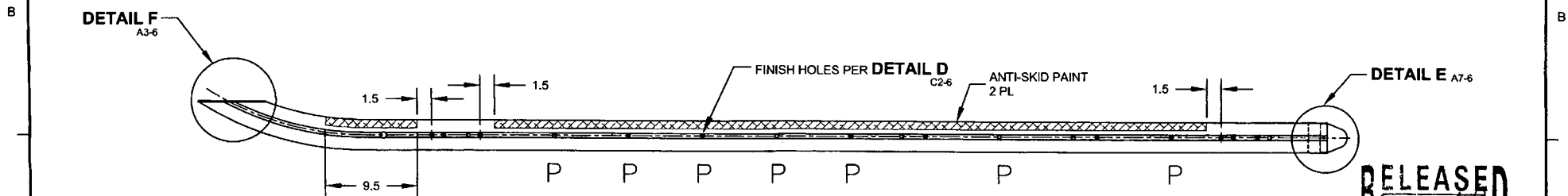
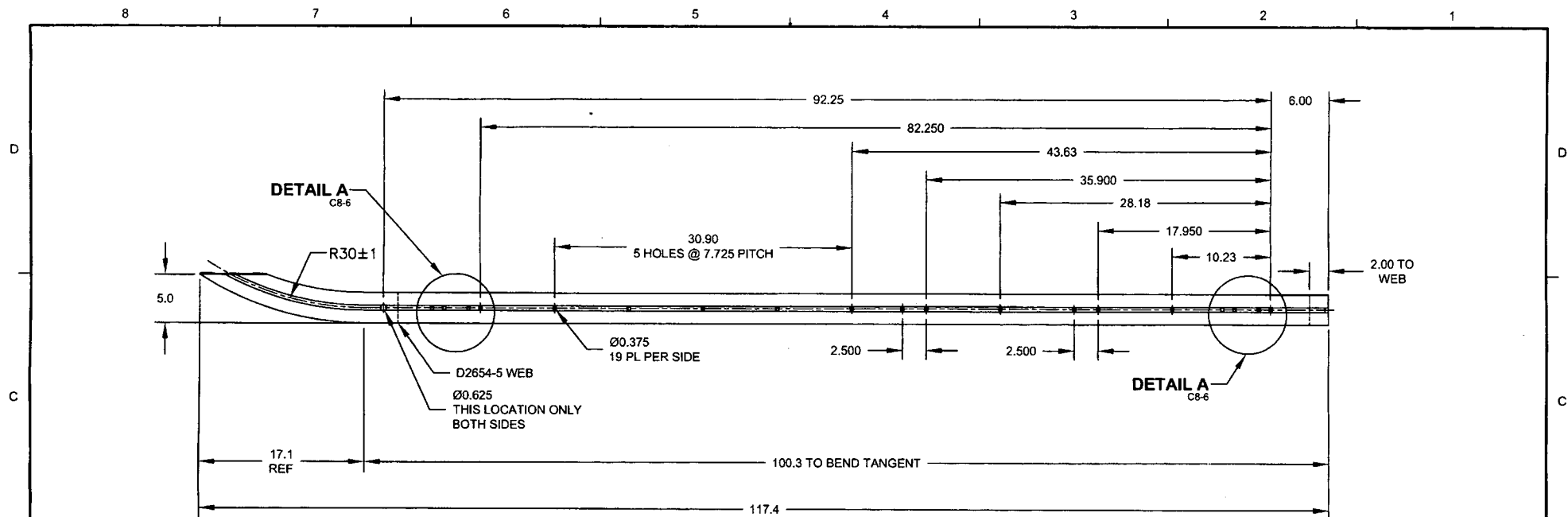


**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
08-07-22

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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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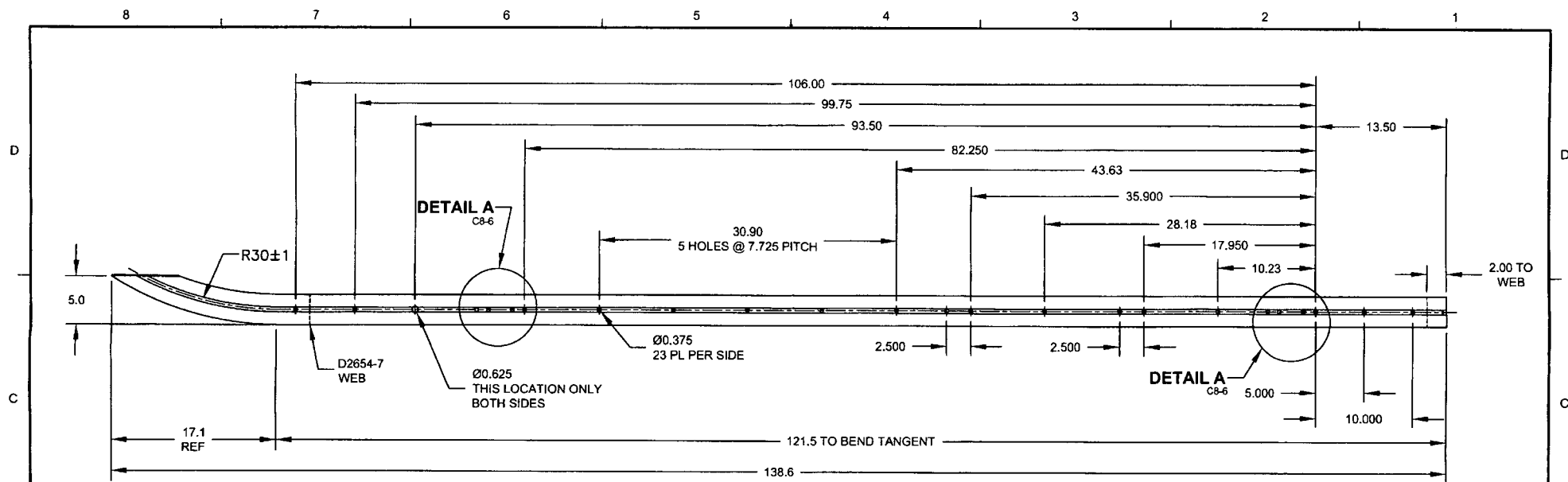
22676



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09-22-1974

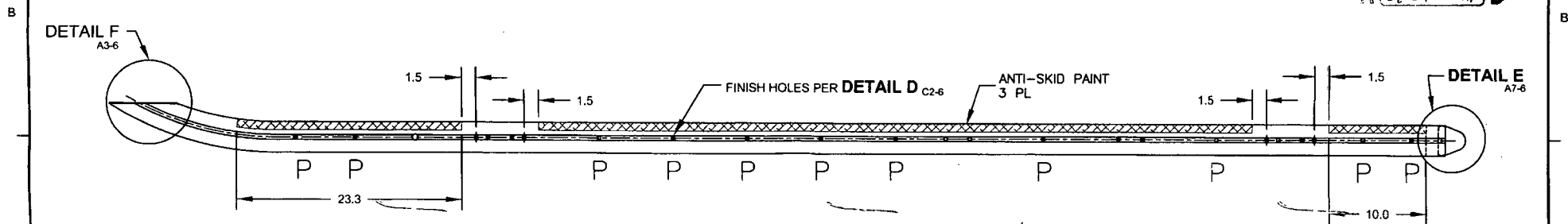
*22676*

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDTUBE ASSEMBLIES	NTS
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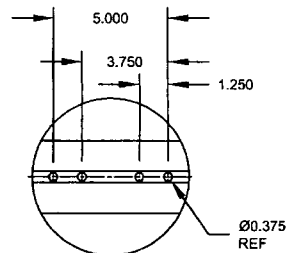
**D2650-7 BENDING/DRILL DETAIL**

**RELEASED**  
08 07 22 1417

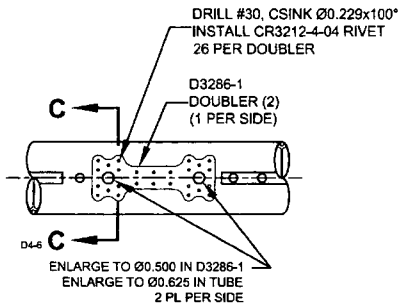


**D2650-7 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5

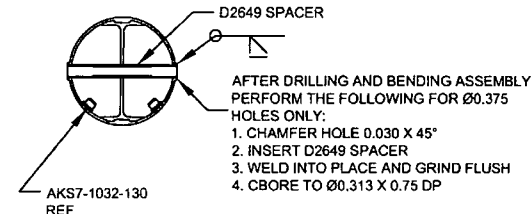
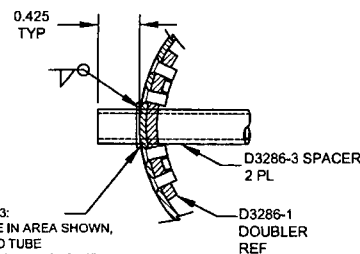


**DETAIL B**  
SCALE 2X  
C3-2  
C3-3

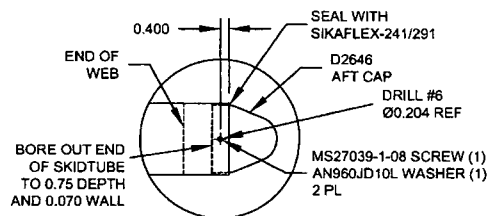
- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO Ø0.500
  4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE.



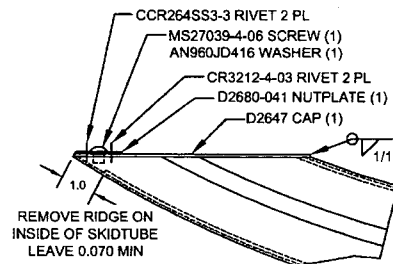
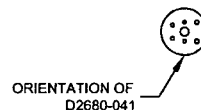
**SECTION C-C** C7-6  
SCALE NONE



**DETAIL D**  
FOR Ø0.375 HOLES ONLY  
SCALE 3X  
B4-2  
B4-3  
B4-4  
B4-5



**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D2647 (TRIM AS NECESSARY)
  4. WELD D2647 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
68-09-22-18

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
1	1	X				D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
1	1				X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
1	1	X				D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
1	1				X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>HA</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>HA</del>	TITLE	SCALE
DE APPR.	<del>HA</del>	WEARSHOE CHANGE	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Date: Friday, 12/12/2008 2:21:07 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
 Job Number : 44043  
 Estimate Number : 10539  
 P.O. Number :  
 This Issue : 12/12/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D206642341  
 First Issue : // Type : SKIDTUBES Drawing Number : D2650 REV F  
 Previous Run : 39151A Material :  
 Written By : Due Date : 10/01/2009 Qty: 1 Um: Each  
 Checked & Approved By : JUD 08 12 15  
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM  
 Est Rev: I 08-09-29 revF as per dwg DD verified by:

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



*for JUD 09/01/29*



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-341 CHG002

*Soderley*

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

*B43845 PM 08-12-15*

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2647

Fwd Cap

*B35475*

*BE 08-12-16*

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod

*M109213*

*BC 08/12/16*

4-Grind weld flush to cap on top surface only.

*BE 08/12/16*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/12/2008 2:21:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end to lenght as per dwg D2650

6-Drill pilot holes using drill Jig DT8168A (A,& B ). Open to Ø0.312"

7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".

8-Open Aft Cap Hole using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650

11-Deburr and Blow out all chips form inside the tube

BE  
Pm' 08-12-16

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Pm' 08-12-16

6.0

D26545

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-5

Web

B 35993

Pm' 08-12-16

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow.12 Hrs. cure time before cutting

Start Date: 08-12-16 Time: 11:45

Finish Date: 08-12-17 Time: 10:30AM

A/R Sikaflex-291 109587

Sikaflex expiry date: 09-07-11

BE  
Pm' 08-12-16

Date: Friday, 12/12/2008 2:21:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/12/17 @*

9.0

D2649

Cross Bolt Spacer



Comment: Qty.: 19.0000 Each(s)/Unit Total: 19.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

19 D2649

Crossbolt spacer

*243803 BE 08-12-17*

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod *m109213 BE 08-12-17*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Deburr

*fm 08-12-17*

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

*1334599*

*fm 08-12-17*

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

*m110122*

*fm 08-12-18*

Date: Friday, 12/12/2008 2:21:07 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cherry Rivet

batch: m10131

pmc 08-12-18

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

pmc 08-12-18

15.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/12/18 @

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/18 @

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FZ 09/01/21 @

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3

Make sure Nut Plate Thread protected use paint screw

START TIME: 1:30 pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:00 pm

09-01-21 @

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m 09.01.22 @

Date: Friday, 12/12/2008 2:21:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B44294

Q.M 09.01.220

21.0

D265611

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-11

Wearshoe

B35899

Q.M 09.01.220

22.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B43407

Q.M 09.01.220

23.0

D265635

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-35

Wearshoe

B35494

Q.M 09.01.220

24.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B43706

Q.M 09.01.220

25.0

ALS41032130

Insert



Comment: Qty.: 54.0000 Each(s)/Unit Total: 54.0000 Each(s)

Pick:

Qty Part Number

Description Batch

54 ALS4-1032-130

Inserts

M105819

Q.M 09.01.220

Date: Friday, 12/12/2008 2:21:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

or (see QSI 017)

26.0

AN960JD10L

Washer



Comment: Qty.: 56.0000 Each(s)/Unit Total : 56.0000 Each(s)

Pick:

Qty Part Number

Description Batch

56 AN960JD10L

Washer M109 632

P.m 09.01.22 ①

27.0

MS27039108

Screw



Comment: Qty.: 56.0000 Each(s)/Unit Total : 56.0000 Each(s)

Pick:

Qty Part Number

Description Batch

56 MS27039-1-08

Screw M11 0467

Q.m 09.01.22 ①

28.0

D26511

Plug



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-1

Plugs B 44342

Q.m 09.01.22 ①

29.0

D26513

O-Ring



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part Number

Description Batch

14 D2651-3

O-Rings B 41972

Q.m 09.01.22 ①

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer M109 161

Q.m 09.01.22 ①



Date: Friday, 12/12/2008 2:21:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw M10 9061

Q.M 09.01.22 @

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B 43901

Q.M 09.01.22 @

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 M109883

Sikaflex expiry date: 09.11

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291 M109883

Sikaflex expiry date: 09.11

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: 11109917A

91 09-01-26 x0

Q.M 09.01.22 @

34.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8 09/01/27 (H)

Date: Friday, 12/12/2008 2:21:08 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 44043

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/27 (4)

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-341

Location: 82

PPP Rev: 2

09/01/29

84

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/02 (8)

Job Completion



JUD 09.01.29 (1)

341  
D44043